

Date: Monday, 7/30/2007 1:54:06 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	205 SKIDTUBE "I" BEAM
Job Number	33796		
Estimate Number	10346		
P.O. Number	N/A	Part Number	D2596
This Issue	7/30/2007	Drawing Number	D2596 REV D
Prsh Rev.	NC	Project Number	N/A
First Issue	N/A	Drawing Revision	D
Previous Run	33451	Material	N/A
Written By		Due Date	8/20/2007
Checked & Approved By	<u>JLM</u> 07.07.30	Qty:	6
Comment	Um: Each Est: D 99.02.02 Changed QA to QC, Added Step 6 and Cost D M Est Rev:E 07-07-09 Incorporated DEO 9183 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D25003100	Ext'n - 'I' Beam Web 4"
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) Extrusion "I" Beam Web 4"		
Pick;		
Qty	Part Number	Description
1	D2500-3-100	Extrusion
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
		
Comment: LANDING GEAR RESOURCE 1 1- Cut D2500-3-100 to length: 99.5" 2- Use Jig DT8093 to drill pilot holes #30 3- Open to 0.630" diameter as per Dwg D2596 4- Deburr		
} - ANM 07/07/02		
3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		
Comment: HAND FINISHING RESOURCE #1 Acid Etch and Alodine per QSI 005 4.1		
4.0	QC5	INSPECT WORK TO CURRENT STEP
		
Comment: INSPECT WORK TO CURRENT STEP		
EP 07/08/03 (10)		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/08/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 7/30/2007 1:54:06 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 SKIDTUBE "I" BEAM

Job Number: 33796

Part Number: D2596

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 46

DP 7-8-3

(6)

6.0 QC21

FINAL INSPECTION/W/O RELEASE



(6)

Comment: FINAL INSPECTION/W/O RELEASE

7-8-03

Job Completion



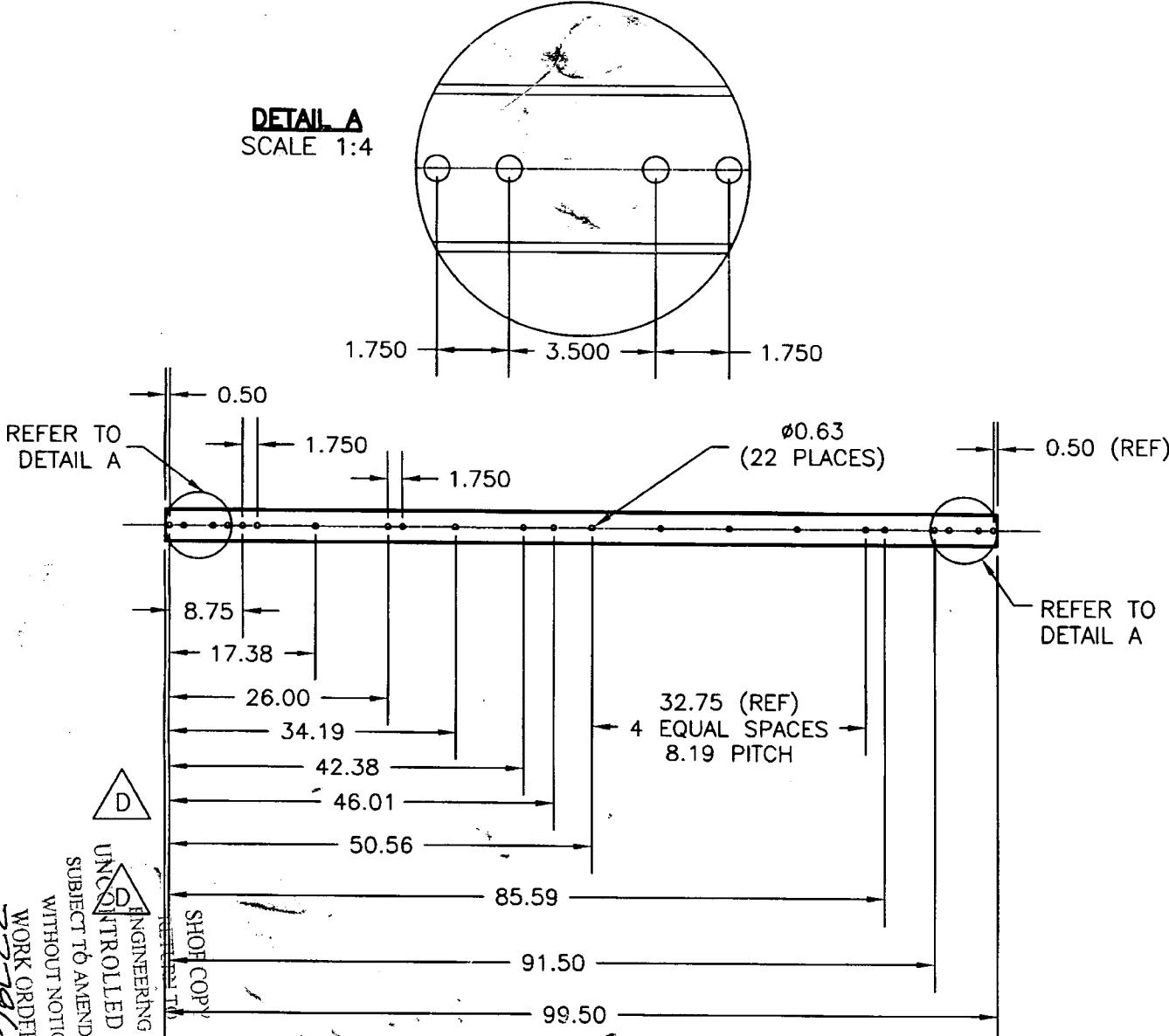
07-08-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DARTDESIGN
*R4*DRAWN BY
*PF*DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADACHECKED
*MF*APPROVED
*MF*DRAWING NO.
D2596REV. D
SHEET 1 OF 1SCALE
1:20**RELEASED**
07 Oct 1996

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

